



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

C3-C-8

Job Sheet 194245



Part No: C3-C-8

Job Qty: 20 pcs

Part Name: Lifting Bushing



Part Weight: 0 lbs

Job Created: 4/29/19

Due Date: 5/17/19

Type: Stock **SOLD**

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: DWG C3-19C Rev F IPP Rev A 18.03.29 New issue DP Verify DD/IPP Rev. B 19.04.25 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier Lead Time	Sign-off
					Setup Hrs	Run Hrs		
110	SL-154 - 1	8 pcs	5/17/19	5/17/19	0.00	4.00	SL-154 - 1	<i>19/05/13</i>
120	QC 2	8 pcs	5/17/19	5/17/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	<i>19/05/13</i>
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	



Container No: S180893



Part: C3-C-8

Job No: 194245

Serial No/Batch: S180893

Revision: G

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/13/19

Plex 4/30/19 7:53 AM Dart.lajeunesse.marie

130 QC 8	8 pcs	5/17/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
150 Outsource - 15 - Nickel Plate	8 pcs	5/17/19		GRO002-VC	10
160 Packaging 2-1 - Receive - B4B	8 pcs	5/17/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	

148 19/5/14
2019-05-14

MAY 22 2019

				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
170 QC 6	8 pcs	5/17/19	0.00 0.00	QC 6 - 9	DAS
				QC 6 - 68	MAY 22 2019 68
				QC 6 - 61	9-89
				QC 6 - 40	
180 Packaging 3-1 - Stock - B4B	8 pcs	5/17/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	8 pcs	5/17/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS MAY 22 2019
				QC 21 - SA - 53	21
Part Op 110 - MORI SL-154 LATHE - 1-Machine as per DWG. FC006 FOLIO REV: <u>AA</u> DWG REV: <u>6</u> 2- Descriptions: Deburr 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 150 - -Issue P/O; _____-Nickel plate, MIL-C-26074 Class 2 Grade B OR QQ-N-290A, Class 2, Grade E -Material type; 4140 -Certificate of Conformity is required 160 - Receive & Inspect for Damage & Mat'l Certs 170 - QC6- All purchased or subcontracted products 180 - Identify as per dwg & Stock Location: <u>GA 193</u> 190 - QC21- Final Inspection - Work Order Release					

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R1.250	AISI 4140 Quenched & Tempered Steel Round Bar 1.250" Dia.	.6640 ft (.083 ea)	110-SL-154 - 1	5017918

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-SL-154 - 1	MT-4140QT-R1.250	1	14	0

Part Specifications

Specifications could not be found.

Plex 4/30/19 7:53 AM Dart.lajeunesse.marie

8

7

6

5

4

3

2

1

D

C

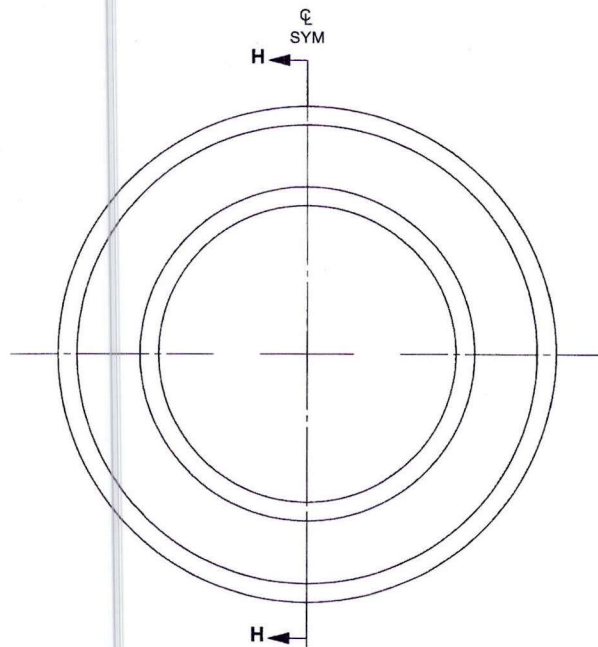
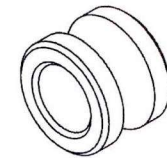
B

D

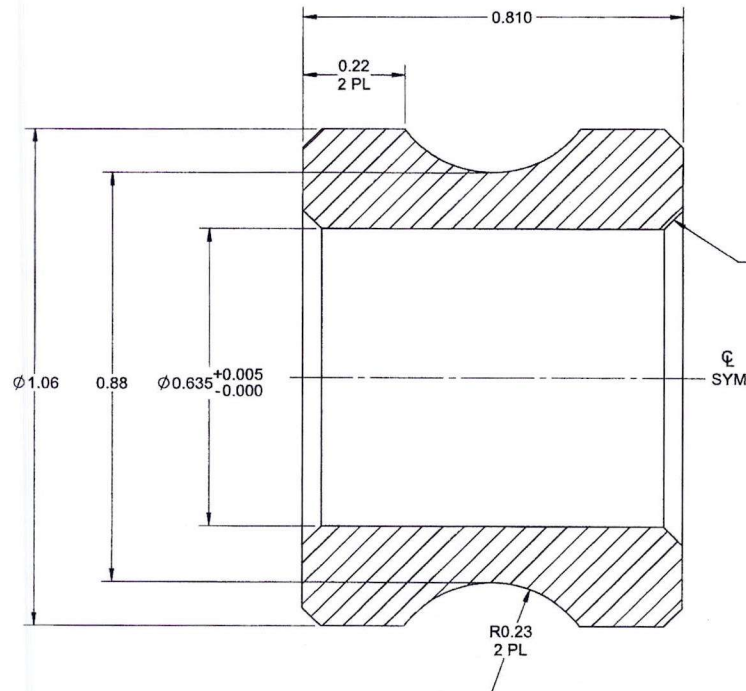
C

B

A



C3-C-8 LIFTING BUSHING



SECTION H-H

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 194245ML5
19-04-29

NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: NICKEL PLATE PER MIL-C-26074 CLASS 2 GRADE B OR QQ-N-290A CLASS 2 GRADE E
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN
DRAWN
CHECKED
MFG. APPR.
APPROVED
DATE 4/26/2019

VM
VM
ML
FK

TOOL PART #
C3-C
TITLE
C3 CAGE

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

REV. F
SHEET 9 OF 10
SCALE
NTS

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NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043454



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043454

PO Date: 5/14/19

Due Date: 5/17/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments: ****RUSH****

E-MAILED
2019-05-15

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	193661	20NR-14	Load Rail (Outside Processing - Nickel Plate)-Issue P/O P/O -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 -Bake after plating -Certificate of Conformity is required	Firmed	-	5/17/19	9 pcs	0 pcs	9 pcs	\$5.60/pcs	\$50.40
2	194621-A	20NR-61	Lock -Issue P/O; -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 -Bake after plating -Material type; 4140 -Certificate of Conformity is required	Firmed	-	5/17/19	5 pcs	0 pcs	5 pcs	\$5.60/pcs	\$28.00
3	192380	20NR-85	Lifting Bolt -Issue P/O; -Nickel plate, QQ-N-290A, Class 2, Grade E or F -Material type; 4340 -Certificate of Conformity is required	Firmed	-	5/17/19	7 pcs	0 pcs	7 pcs	\$8.91/pcs	\$62.37



Dart Aerospace Ltd.
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PURCHASE ORDER

POHB043454



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	194245	C3-C-8	Lifting Bushing -Issue P/O; -Nickel plate, MIL-C-26074 Class 2 Grade B OR QQ-N-290A, Class 2, Grade E -Material type; 4140 -Certificate of Conformity is required	Firmed	-	5/17/19	20 pcs	0 pcs	20 pcs	\$0.85/pcs	\$17.00
Grand Total:											\$157.77

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 5/15/19 9:15 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(019207-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

019207- 1

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
16-May-2019		SVETLANA DORZHIYEVA		POHB043454				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	20NR-14 Rev.	20NR-14 01 -E-NIC STEEL 200 [E-NICKEL STEEL 200] NICKEL-PLATE, QQ-N-290,CLASS2, GRADE E OR F NICKEL PLATE 0.0004-0.0006 BAKE AFTER PLATING	E-NICKEL STEEL CH	9	9	0	0	0
2	20NR-61 Rev.	20NR-61 01 -E-NIC STEEL 200 [E-NICKEL STEEL 200] NICKEL PLATE QQ-N-290 CLASS 2 GRADE E OR F 0.0004 TO 0.0006 THICK BAKE AFTER PLATING MATERIAL TYPE; 4140	E-NICKEL STEEL CH	5	5	0	0	0
3	20NR-85 Rev.	20NR-85 01 -E-NIC STEEL 200 [E-NICKEL STEEL 200] NICKEL PLATE QQ-N-290 CLASS 2 GRADE E OR F MATERIAL TYPE; 4140	E-NICKEL STEEL CH	7	7	0	0	0
4	C3-C-8 Rev.	C3-C-8 01 -E-NIC STEEL 200 [E-NICKEL STEEL 200] NICKEL PLATE, MIL-C-26074 CLASS 2 GRADE B OR QQ-N-290A, CLASS 2, GRADE E MATERIAL TYPE; 4140	E-NICKEL STEEL CH	20	20	0	0	0

RECEIVED

MAY 21 2019

DART AEROSPACE LTD.

RECEIVED

MAY 21 2019

DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

4 boxes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.